

Date: Monday, 7/9/2007 11:39:13 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SADDLE KIT FOR D206-642-511		
Job Number	33318			Part Number	K642 511	
Estimate Number	12893			Drawing Number	N/A	
P.O. Number	:			Project Number	N/A	
This Issue	7/9/2007	S.O. No. :		Drawing Revision	N/A	
Prsht Rev.	NC			Material	:	
First Issue	/ /			Due Date	7/16/2007	Qty: 3 Um: Each
Previous Run	33229					
Written By	:					
Checked & Approved By	<u>John</u> 07.07.09					
Comment	Est Rev A 07.06.05 new issue EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP K642-511 CHG003	
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
3.0	D206648013	GHW Kit	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) GHW Kit Batch: <u>B 32401</u> ✓ <u>C</u>	
4.0	D2652	Bushing	
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 48.0000 Each(s) Pick: Qty Part Number Description Batch 16 D2652 Bushing <u>B 32621</u> ✓ <u>S</u>	
5.0	D2712	Set Screw	
		Comment: Qty.: 10.0000 Each(s)/Unit Total : 30.0000 Each(s) Pick: Qty Part Number Description Batch 10 D2712 Set Screw <u>B 32506</u> ✓ <u>7/8/15P</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE KIT FOR D206-642-511
Job Number: 33318		Part Number: K642 511
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	D29321	206 Saddle Left side 
		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) <i>SP +3</i>
		Pick: Qty Part Number Description Batch 1 D2932-1 Saddle <i>B32021 ✓ SP</i>
7.0	D29331	206 Saddle Left 
		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) <i>SP +3</i>
		Pick: Qty Part Number Description Batch 1 D2933-1 Saddle <i>B32379 ✓ SP</i>
8.0	D2934	Saddle Spacer 
		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) <i>SP +3</i>
		Pick: Qty Part Number Description Batch 2 D2934 Saddle Spacer <i>B32628 ✓ SP</i>
9.0	D2935	Saddle Spacer 
		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) <i>SP +3</i>
		Pick: Qty Part Number Description Batch 2 D2935 Saddle Spacer <i>B33219 ✓ SP</i>
10.0	D29381	206 Saddle Left side 
		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) <i>SP +3</i>
		Pick: Qty Part Number Description Batch 1 D2938-1 Saddle <i>* (2) B30281 ✓ (1) SP 32381 ✓</i>
11.0	D29391	206 Saddle Left side 
		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) <i>SP +3</i>
		Pick: Qty Part Number Description Batch 1 D2939-1 Saddle <i>B31252 ✓ 7/8/1, SP</i>

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33318

Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D33963 Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number
2 D3396-3

Description Batch
Spacer 1328784 ✓

SD

13.0 D3407043 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number
1 D3407-043

Description Batch
Tow Ring 1332893 ✓

SD

14.0 D34561 washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number
1 D3456-1

Description Batch
Washer 1325301 ✓

SD

15.0 D34571 Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number
2 D3457-1

Description Batch
Washer 132409 ✓

SD

16.0 AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number
3 AN3C35A

Description Batch
Bolt 11041955 ✓

SD

17.0 AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 27.0000 Each(s)

Pick:

Qty Part Number
9 AN3C36A

Description Batch
Bolt 11041261 ✓

7/8/159

W/O:		WORK ORDER CHANGES					
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Job Number: 33318

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M105118 ✓

SP

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M104936 ✓

SP

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M105143 ✓

SP

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M104936 ✓

SP

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M104936 ✓

SP

23.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M101291 ✓

7/8/1 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 33318

Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation:

Description :

24.0 AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M105176 ✓

SP

25.0 AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M18918 ✓

SP

26.0 AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M18918 ✓

SP

27.0 AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M105143 ✓

SP

28.0 AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M1041916 ✓

7/8/11 SP

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33318

Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation:

Description :

29.0 AN960C516L WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number
8 AN960C516L

Description
Washer

Batch

M103344 ✓

59

30.0 MS210433 Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number
20 MS21043-3

Description
Nut

Batch

M104995 ✓

59

31.0 MS210434 Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 39.0000 Each(s)

Pick:

Qty Part Number
13 MS21043-4

Description
Nut

Batch

M101936 ✓

59

32.0 MS210435 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number
4 MS21043-5Nut

Description
Batch

M104729 ✓

59

33.0 NAS1515H3L WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number
24 NAS1515H3L

Description
Washer

Batch

M102536 ✓

34

M104291 ✓

34.0 NAS1515H4L



Inventory

M101542 ✓ *M10536* ✓

7/8/15

Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

7/8/15

W/O:		WORK ORDER CHANGES						
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Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 33318

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24 NAS1515H4L Washer

35.0 NAS1515H5 Washer

Comment: Qty.: 16.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 16 NAS1515H5

Washer

M105057 ✓

14

SP

36.0 NAS1515H5L WASHER

Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 8 NAS1515H5L

Washer

M104956 ✓

7/8/07 SP

37.0 QC4 INSPECT 100% KITS FOR COMPLETENESS

07/08/07

Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0 PACKAGING 1 PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location: _____

39.0 QC21 FINAL INSPECTION/W/O RELEASE

07/08/07 (3)

Comment: FINAL INSPECTION/W/O RELEASE

07-08-15

Job Completion



U 07-08-15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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